

5/47

DART AEROSPACE LTD	Work Order:	24620
Description: Stop	Part Number:	D2805-2
Dwg: D2805 rev. <i>XB</i>	Qty:	20

*LP 506.21*

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Issue W/O	<i>[Signature]</i>	05.10.21	20
2	METAL	Cut blanks: 3.150" long -0.010" +0.030" Material: 6061-T6 (QQ-A-200/8) or (QQ-A-250/11) 1.5" x 1.5" bar Batch: <i>M16954</i>	BG	05.10.06	20
3	HAAS	Machine as per folio FA104	BG	05.10.06	20
4	QC	Inspect Level 2	BG	05.10.06	20
5	QC	Inspect Level 8	SA	05.11.06	20
6	METAL	Tumble & Deburr <i>N/A</i>	BG	05.11.06	20
7	QC	Inspect Level 5	BG	05.11.06	20
8	FINISHING	Acid etch and Alodine per QSI 005	LO	05/11/15	20
9	STORES	Identify and stock	LO	05/11/16	20
10	EXPEDITING	Close W/O Cost / part: <i>12.22 sur 05/11/21</i> <i>(20)</i>	<i>[Signature]</i>	05/11/21	20

*Loc. 379**01*

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	
B	00.11.14	Revised Finishing step to Acid etch and Alodine	EC	<i>[Signature]</i>

RELEASED

*EC 00.11.27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RS Date: 05/11/21

NOTE: Date & initial all entries

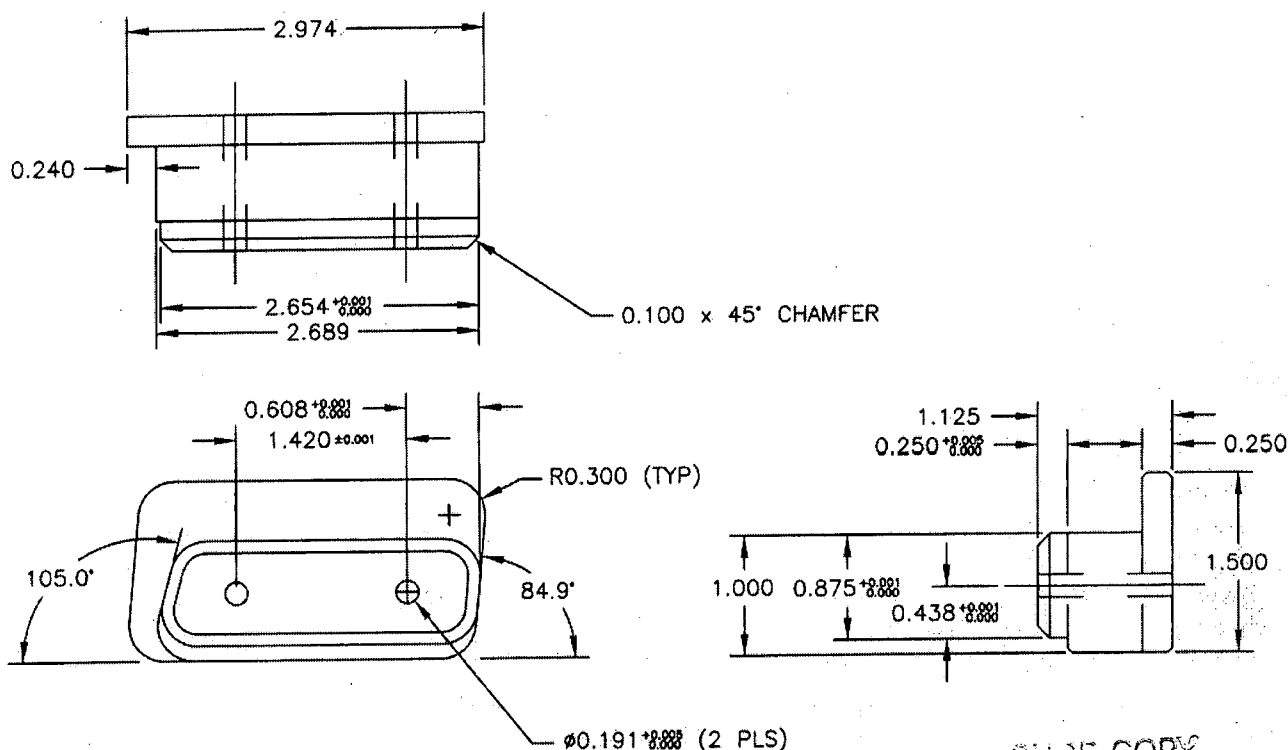
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED  
01.03.16 #



D2805-1 (SHOWN)  
D2805-2 (OPPOSITE)

SHOE COPY  
FURNISH TO  
ENGINEERING  
FILED COPY  
FOR ATTACHMENT  
WITHOUT NOTICE

WORK ORDER

NO. 24620

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.  
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

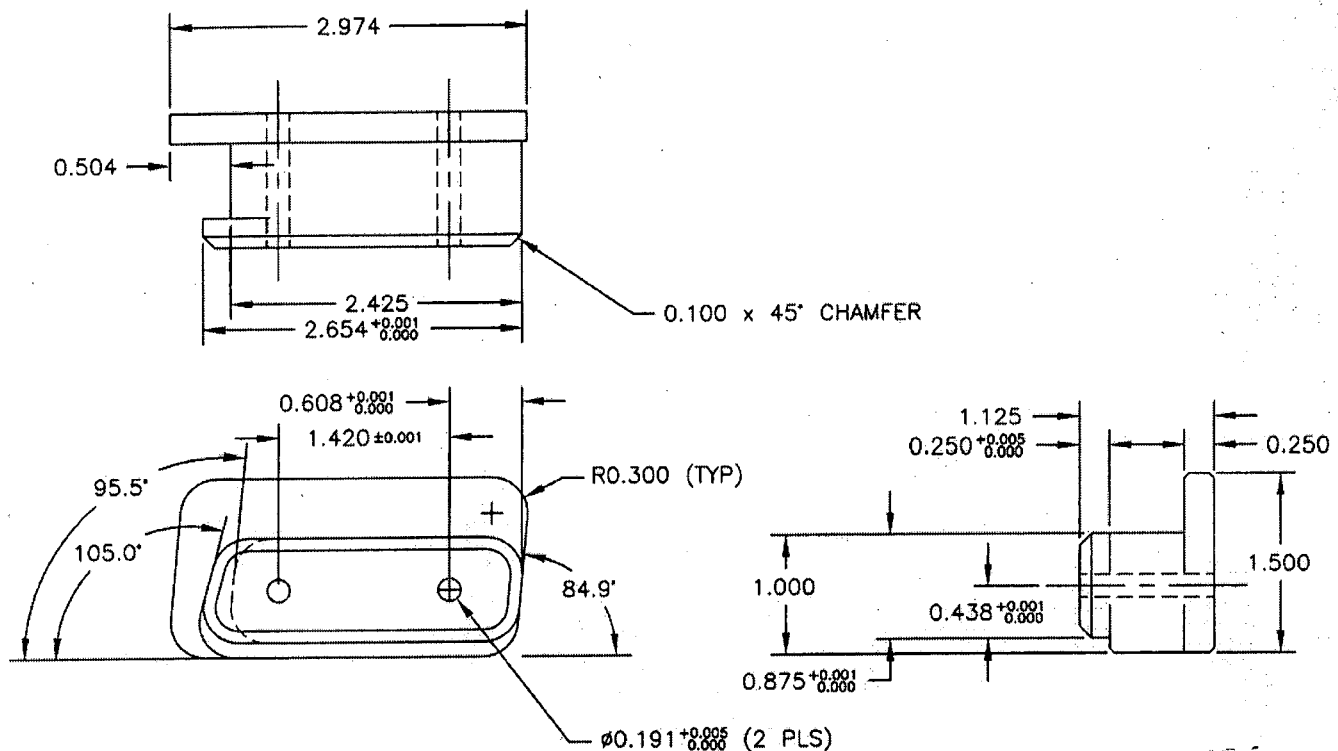
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED  
01.03.16



D2805-3 (SHOWN)  
D2805-4 (OPPOSITE)

SHOP COPY  
SUBMIT TO  
ENGINEERING  
UNLESS OTHERWISE NOTED  
SUBMIT TO  
ENGINEERING

WORK ORDER  
NO. 24620

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.  
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 20, 2005  
04:09 pm

Work Order No : 0024620  
Project Name : D2805-2  
Project For : WK547  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2805-2  
Description : Stop  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 10-20-05  
Est Finish Date : 11-23-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
12:26 pm

Work Order No : 0024620  
Project Name : D2805-2  
Project For : WK547  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2805-2  
Description : Stop  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 10-20-05  
Est Finish Date : 11-23-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

MIS 8/B  
a  
11.15

Date: Monday, 14/11/2005 3:47:25 PM  
 User: Alba Panzuto

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: STOP
<b>Job Number</b>	: 24620		
<b>Estimate Number</b>	: 10513		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D28052
<b>This Issue</b>	: 14/11/2005	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2805 REV. B
<b>First Issue</b>	: / /	<b>Project Number</b>	:
<b>Previous Run</b>	:	<b>Drawing Revision</b>	: B
	<b>Type</b> : MACHINED PARTS	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 30/11/2005
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	20
<b>Comment</b>	: Est: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC	<b>Um:</b>	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"
2.0	BAND SAW	BAND SAW
<b>Comment:</b> BAND SAW Cut Bar: 3.150" Long +0.010/-0.030"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA104 and Dwg D2805 2- Tumble and Deburr Identify as D2805-2		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<b>Comment:</b> HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		



Date: Monday, 14/11/2005 3:47:25 PM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 24620

Part Number: D28052

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

Job Completion

